

20

5th

DART AEROSPACE LTD			Work Order:	20651																																											
Description: Bearpaw Kit (48" x 19") 205/430			Part Number:	K10015																																											
Dwg: D2521 Rev. H			Qty:	10 Kits																																											
Ref: K10015 Rev. A; DSK086-6 Rev. A			Page 1 of 1																																												
Step	Location	Procedure	By	Date	Qty																																										
1	DC	Issue Traveler <b>Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required</b>	HJ	04.04.01	10																																										
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 <b>(Bag Bluefiles separately)</b>	JK 18 HJ	04.04.30	10																																										
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: M14864	ED	04/04/26	10																																										
4	MV	Inspect material for defects or damage prior to machining	ED	04/04/26	10																																										
5	MV	Machine as per Folio FA222 and Dwg D2521 <b>Identify as D2521</b>	ED	04/04/30	10																																										
6	QC2	Inspect parts as they come off the CNC machine	ED	04/04/30	10																																										
7	MV	Deburr	ED	04/04/30	10																																										
8	MV	Form as per Dwg D2521 using bending Jig DT8328	ED	04/04/30	10																																										
9	QC8 & 5	Second inspection	ED	04/05/03	10																																										
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table border="1"> <thead> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> </thead> <tbody> <tr> <td>8 ✓</td><td>D2182B055</td><td>Rubber Cushion</td><td>B20434</td></tr> <tr> <td>16 ✓</td><td>D2274</td><td>Radius Block</td><td>B20655</td></tr> <tr> <td>2</td><td>D2521</td><td>Bearpaw</td><td>B20651</td></tr> <tr> <td>16 ✓</td><td>D2529</td><td>Washer</td><td>B20388</td></tr> <tr> <td>8 ✓</td><td>D2947</td><td>Clamp</td><td>B19106/B 19991</td></tr> <tr> <td>16 ✓</td><td>AN4-15A</td><td>Bolt</td><td>m14544</td></tr> <tr> <td>16 ✓</td><td>AN960JD416</td><td>Washer</td><td>m14312</td></tr> <tr> <td>16 ✓</td><td>MS21042L4 ✓</td><td>Nut (or -4)</td><td>m14149</td></tr> <tr> <td>1</td><td colspan="3">Paperwork package from Step 2 ✓</td><td></td><td></td></tr> </tbody> </table>	Qty	Part Number	Description	Batch	8 ✓	D2182B055	Rubber Cushion	B20434	16 ✓	D2274	Radius Block	B20655	2	D2521	Bearpaw	B20651	16 ✓	D2529	Washer	B20388	8 ✓	D2947	Clamp	B19106/B 19991	16 ✓	AN4-15A	Bolt	m14544	16 ✓	AN960JD416	Washer	m14312	16 ✓	MS21042L4 ✓	Nut (or -4)	m14149	1	Paperwork package from Step 2 ✓						04/05/03	10
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1	Paperwork package from Step 2 ✓																																														
11	QC4	Inspect Kit for 100% Completeness on the W/O	ED	04/05/04	10																																										
12	PK	Identify and pack for shipping as per PPP K10015	REV C	04/05/04	10																																										
13	AC	Cost / part 366.17	SAT	04-05-05	10																																										
14	DC	Close W/O 366.26 Inspect Level 21	HJ	04.05.06	10																																										

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	#

BB 04-05-05 DS.

RELEASED  
04.02.20

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 20651		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04-05-29	5	- Bottom aft area of bearpaw damaged, one (1) part affected	Initial	Blend damaged area to a smooth finish	E 04.05.30	B 04-05-03	J 04-05-03	J 04-05-30	B 04-05-03
				Make a matching bearpaw.	E 04.05.30				

PAR#: N/A.

Fault Category: manuf -cnc

DQA: 16

Date: 04.05.06

DART AEROSPACE LTD

Work Order:

20651

Description: Bearpaw

Part Number:

D2521

Inspection Dwg: D2521

Rev: H

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## FIRST ARTICLE INSPECTION CHECKLIST

 First Article     Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.000	+/-0.030	1.002	✓	vern	
B	5.600	+/-0.030	5.595	✓	vern	
C	11.500	+/-0.030	11.500	✓	12" vern	
D	10.250	+/-0.010	10.260	✓	12" vern	
E	13.250	+/-0.010	13.250	✓	tape measure	
F	8.500	+/-0.010	8.500	✓	12" vern	
G	22.125	+/-0.030	22.125	✓	tape measure	
H	8.75	+/-0.010	8.74	✓	12" vern	
I	44.500	+/-0.030	44.500	✓	tape measure	
J	6.688	+/-0.030	6.691	✓	12" vern	
K	5.625	+/-0.030	5.612	✓	vern	
L	7.000	+/-0.030	7.016	✓	12" vern	
M	5.000	+/-0.010	5.000	✓	vern	
N	4.000	+/-0.030	3.990	✓	vern	
O	6.625	+/-0.030	6.638	✓	12" vern	
P	19.000	+/-0.030	19.000	✓	tape measure	
Q	0.31 x 45°	+/-0.030	0.31 x 45°	✓	vern	
R	0.19 x 45°	+/-0.030	0.1845 x 45°	✓	vern	
S	0.50 x 45°	+/-0.030	0.50 x 45°	✓	vern	
T	0.38 x 45°	+/-0.030	0.38 x 45°	✓	vern	
U	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓	vern	
V	Ø0.260	+0.005/-0.000	Ø0.260	✓	vern	
W	Ø0.93	+/-0.030	Ø0.932	✓	vern	
X	0.30	+0.030/-0.010	0.306	✓	vern	
Y	0.375	+/-0.010	0.381	✓	vern	
Z	0.750	+/-0.030	0.750	✓	vern	
AA	0.250	+/-0.010	0.257	✓	vern	
AB	4.000	+/-0.030	Same as "N"	✓		
AC	6.625	+/-0.030	Same as "O"	✓		
AD	0.950	+0.030/-0.010	0.965	✓	vern	
AE	0.375	+/-0.010	0.375	✓	vern	
AF	3.399	+/-0.030	3.399	✓	vern	
AG	6.625	+/-0.030	6.620	✓	12" vern	

Measured by:	<i>ED</i>	Audited by:	<i>RE</i>	Prototype Approval:	N/A
Date:	04/04/27	Date:	04.04.27	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/0 K10015	<i>DR</i>

RELEASED

#04.01.15

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyApr 01, 2004  
02:23 pm

Work Order No : 0020651  
 Project Name : \*K10015  
 Project For : WK420  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : \*K10015  
 Description : Bearpaw Kit  
 Manufactured : Yes  
 Amount Req'd : 10  
 Amount Done : 0  
 Start Date : 04-01-04  
 Est Finish Date : 05-13-04  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Margin : 0.000%  
 Actual Margin : 0.000%

	Estimated	Actual	Vár. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00